

DART AEROSPACE LTD	Work Order :	20894
K10015	Description:	Inspection
	Approval :	BB
		Page 1 of 1

Step	Location	Procedure	By	Date																																																		
1	PK	Remove from Stock Yes/No Return <del>#</del> from HAT <table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>K10015</td> <td>Bearpaw kit</td> <td>B19984</td> </tr> <tr> <td>1</td> <td>K10015</td> <td>Bearpaw kit</td> <td>B19099</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	K10015	Bearpaw kit	B19984	1	K10015	Bearpaw kit	B19099																																								
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2		Re-work/Inspection: Notes - The paperwork for the two kits were destroyed. - The hardware for the <del>PK</del> K10015 B19984 was used from HAT - The hardware for the K10015 B19099 was not returned from EagleCopters <ul style="list-style-type: none"> <li>(A) Inspect bearpaws for damage</li> <li>(B) Pick new kits</li> </ul> <table> <thead> <tr> <th></th> <th></th> <th>Batch</th> <th></th> <th></th> </tr> </thead> <tbody> <tr> <td>✓</td> <td>8 D2182B055</td> <td>Rubber cushion</td> <td>B19540</td> <td>CP 04/03/24 2</td> </tr> <tr> <td>✓</td> <td>16 D2274</td> <td>Radius Block</td> <td>B20207</td> <td></td> </tr> <tr> <td>✓</td> <td>2 D2521</td> <td>Bearpaw</td> <td>B19103 / B19984</td> <td>BB 04-03-23</td> </tr> <tr> <td>✓</td> <td>8 D29117</td> <td>Clamps</td> <td>B19106</td> <td></td> </tr> <tr> <td>✓</td> <td>16 D2529</td> <td>Washer</td> <td>B19486</td> <td></td> </tr> <tr> <td>✓</td> <td>16 ANH-15A</td> <td>Bolt</td> <td>M14115</td> <td>CP 04/03/24 2</td> </tr> <tr> <td>✓</td> <td>16 AN9603D416</td> <td>Washer</td> <td>M14312</td> <td></td> </tr> <tr> <td>✓</td> <td>16 MS21042-4V/L4</td> <td>Nut</td> <td>M5461</td> <td></td> </tr> <tr> <td></td> <td>paper work</td> <td></td> <td></td> <td></td> </tr> </tbody> </table> <ul style="list-style-type: none"> <li>(C) Inspect kit for completeness</li> </ul>			Batch			✓	8 D2182B055	Rubber cushion	B19540	CP 04/03/24 2	✓	16 D2274	Radius Block	B20207		✓	2 D2521	Bearpaw	B19103 / B19984	BB 04-03-23	✓	8 D29117	Clamps	B19106		✓	16 D2529	Washer	B19486		✓	16 ANH-15A	Bolt	M14115	CP 04/03/24 2	✓	16 AN9603D416	Washer	M14312		✓	16 MS21042-4V/L4	Nut	M5461			paper work				BB	04-03-24
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4	PK	Package and identify as per PPP K10015 Rev.C	CP	04/03/25 2																																																		
5	DC	Close W/O Inspect Level 21	BB	04.03.26 2																																																		

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DART AEROSPACE LTD			Work Order:	19984
Description: Bearpaw Kit (48" x 19") 205/430		Part Number:		K10015
Dwg: D2521 Rev. H		Qty:		600 Kits
Ref: K10015 Rev. A		Page 1 of 1		
Step	Location	Procedure	By	Date
1	DC	Issue Traveler Note: (1) K10015 Kit consists of Qty (2) D2521 Dwg not required		03.11.24 510
2	DC	Photocopy bluefile: K10015 D205-564-011 D430-688-011 and create labels per PPP K10015 CHG002 (Bag Bluefiles separately)		03.11.27 56
3	GA	Cut 2 blanks per (1) K10015 Kit Cut blank: 19.50" x 48.00" x 1.00" thick Material: Black UHMW 1" (MUHMWB10)	M14320 M14111	04.01.08 10
4	MV	Inspect material for defects or damage prior to machining		04/01/31 6
5	MV	Machine as per Folio FA222 and Dwg D2521		04/01/31 6
6	QC2	Inspect parts as they come off the CNC machine		04/01/31 6
7	MV	Deburr		04/01/31 6
8	MV	Form as per Dwg D2521 using bending Jig DT8328		04/02/03 6
9	QC8 & 5	Second inspection		04.01.31 6
10	KP	Pick: Packing Kit (Note: D2521 is on the BOM as material from step 3)		
		Qty Part Number Description Batch		
		8 D2182B055 Rubber Cushion B19540		
		16 D2274 Radius Block B19599		
		2 D2521 Bearpaw B19984		
		16 D2529 Washer B19786		
		8 D2947 Clamp B19106- B19747		
		16 AN4-15A Bolt M13437 M13437		
		16 AN960JD416 Washer M13719		
		16 MS21042L4 Nut (or -4) M13276		
		1 Paperwork package from Step 2		
11	QC4	Inspect Kit for 100% Completeness on the W/O		04-02-03 6
12	PK	Identify and pack for shipping as per PPP K10015		04-02-03 6
13	AC	Cost / part 401.12		04-02-04 6
14	DC	Close W/O 387.50 Inspect Level 21		04.02.05 6

Rev	Date	Change	Revised By	Approved
A	01.10.16	K10015 created for Bearpaw Kit (MPP 2164)	SM	
B	03.05.26	Reformat; Incorporated D2521	KJ/RF	

BB 04-02-04. DK.

RELEASED  
03.07.01 RF

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DART AEROSPACE LTD		Work Order:	19099
Description: Bearpaw Kit (205/430)		Part Number:	K10015
Drawing: K10015 rev. A		Qty:	34

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order		03.05.01	34
2	EXPEDITING	Photocopy blue file: K10015 D205-564 D430-688 labels per PPP K10015 CHG0012 <b>(Bag Blue files separately)</b>		RF 03.05.12	
3	STORES	Pick: Qty      Part Number      Description      Batch 8      D2182B055      Rubber cushion      B18914 16      D2274      Radius block B18911-      B189143 2      D2521      Bearpaw      B19103 8      D2947      Clamp B19106      B19839 16      D2529      Washer      B19930 16      AN4-15A      Bolt M12903 -      M12907 16      AN960JD416      Washer      M12749 16      MS21042-4(L4)      Nut      M12620 1      paper work package from step 2		03.05.16	34
4	QC	Inspect Level 4		03.05.16	34
5	STORES	Package and Identify as per PPP K10015	REV.C	03.06.01	34
6	EXPEDITING	Close Work Order Cost / part: 355.93 5.46-03/06/10 (34)		03.06.09	

Rev	Date	Change	Revised By	Approved
A	01.10.16	K10015 created for Bear paw kit (MPP 2164)	SM	EC

BB 03-06-10 DB

RELEASED

EC 01.10.16

REFERENCE ONLY